

Work Order ID 69741

Wednesday, May 18, 2011 10:51:25 AM



Page 1

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 5/18/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

5/24/05/19 (40)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

JB 11/05/19

(40)

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. ***DO NOT TIGHTEN
BOLTS*** Identify as D3278-041

5/24/05/19 (40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 5/18/2011 Start Qty: 40.00

Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/05/19

(40)

140

Identify as per dwg & Stock Location: 9471

0.00



Packaging

Memo

0.00

Packaging

9/5/05/24 (40)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/25
ME
11-05-25

W/O:		WORK ORDER CHANGES						
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Picklist Print

Wednesday, May 18, 2011 10:51:54 AM

Page 1

Work Order ID: 69741

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 5/18/2011

Required Date: 5/20/2011





Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1  Support		Manufactured	No			100	Each	45.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				45					
				67772				5					
				68956				40					
D3278-2  Support		Manufactured	No			100	Each	40.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				40					
				68959				40					
D3278-3  Spacer		Manufactured	No			100	Each	74.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				74					
				68340				74					
MS21042L4  Nut		Purchased	No			100	Each	4,821.000	2	80			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST300				4821					
				116823				1021					
				117441				3000					
				117601				800					

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, May 18, 2011 10:51:54 AM

Page 2

Work Order ID: 69741

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 5/18/2011

Required Date: 5/20/2011

Start Qty: 40.00

Required Qty: 40.00

AN4-13A	Purchased	No	120	Each	245.0000	2	80
Bolt							

Location

Loc Qty

Loc Code

ST357

245

117628

245

120

Each

0.0000

4

160

AN960JD416

NAS1149D0463J

Purchased

No



47 M117291

(160)

Washer

D2230-1

Manufactured

No

120

Each

160.0000

2

80



Lug

Location

Loc Qty

Loc Code

ST476

160

67761

72

67826

88

120

Each

3,717.000

4

160

MS20426AD3-6

Purchased

No



Rivet

Location

Loc Qty

Loc Code

ST316

3717

105055

147

116289

3570

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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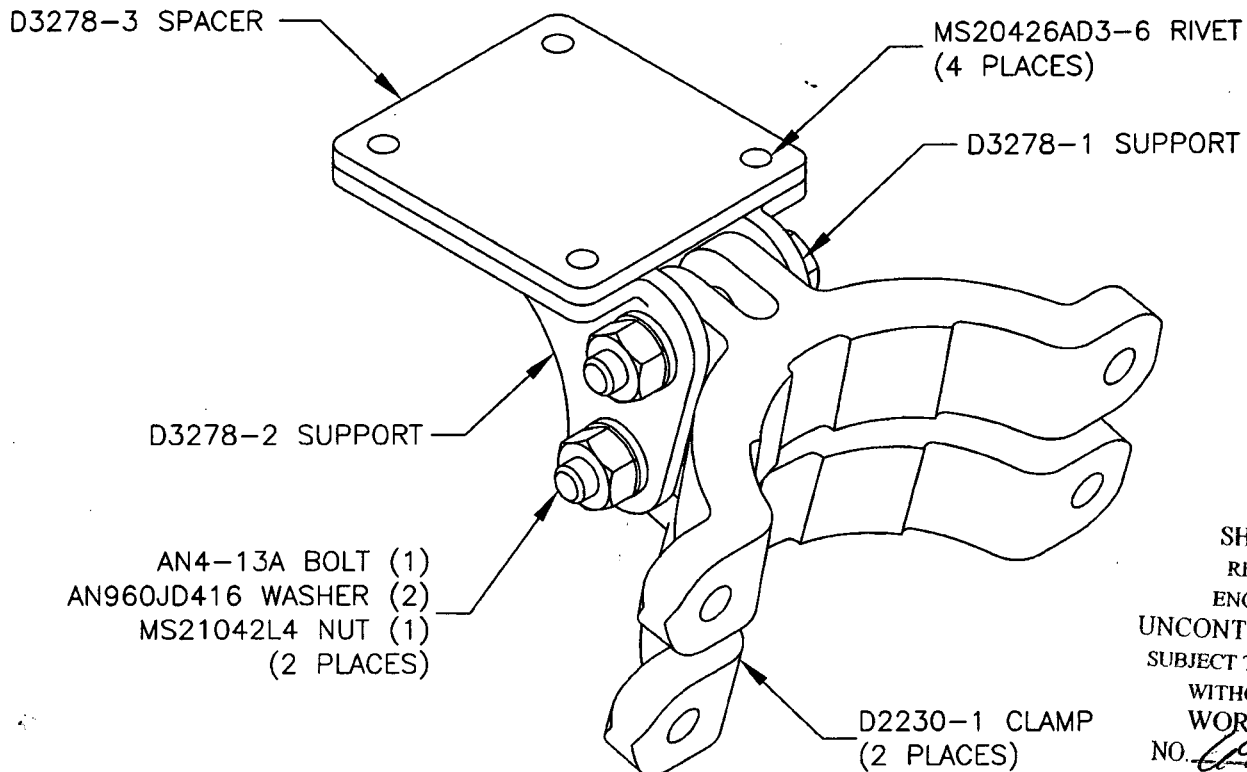
NOTE: Date & initial all entries

DART

DESIGN <i>97</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *69741*

011-05-18

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

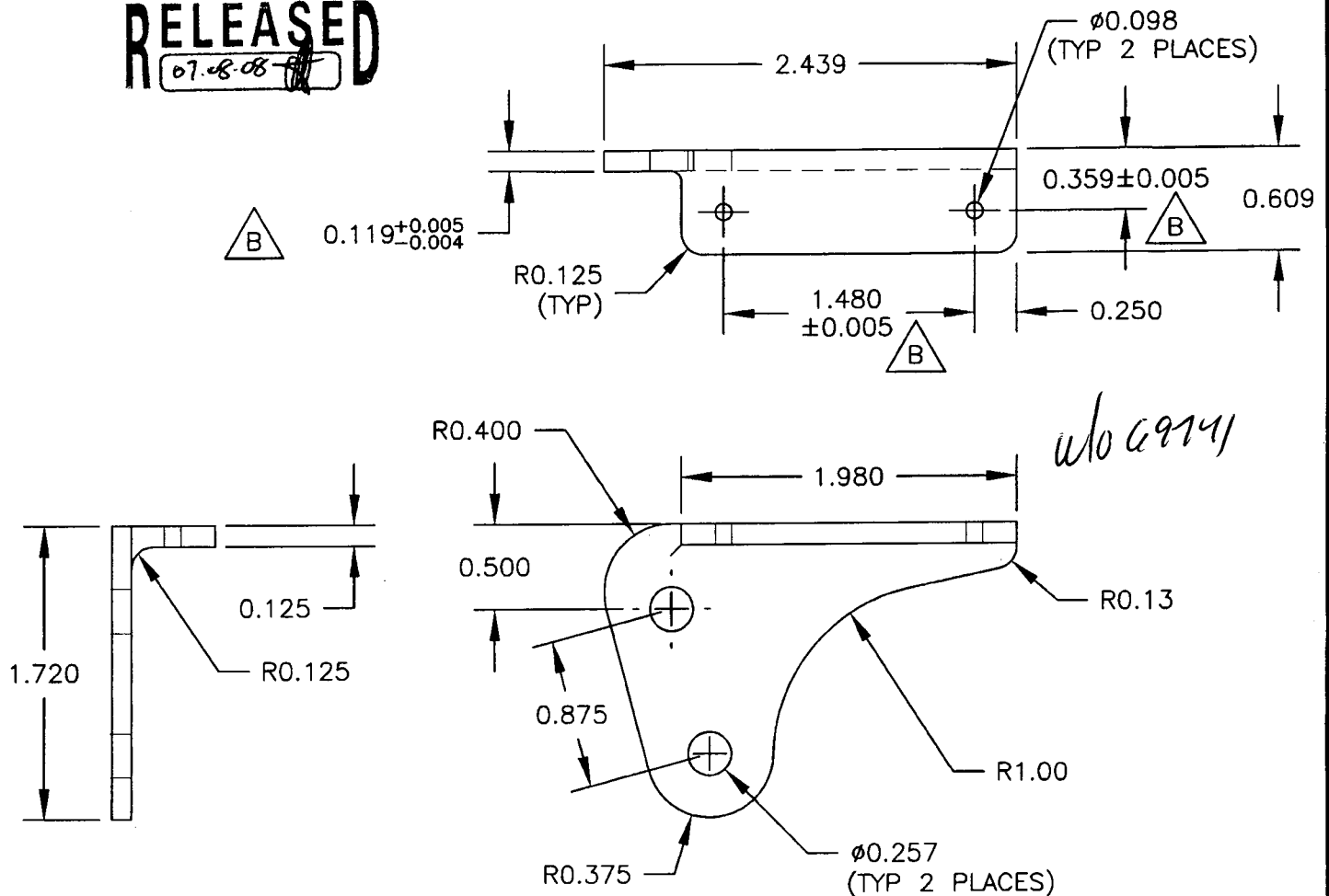
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

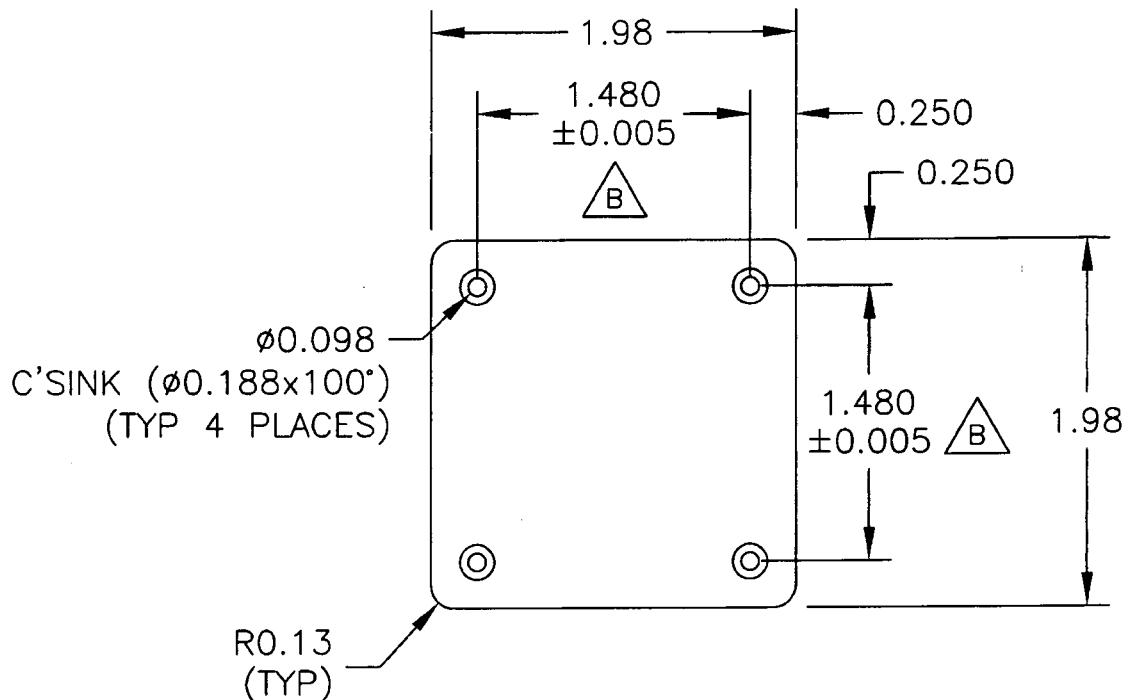
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08*u/b G9141***D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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